

Monday, October 24, 2016 11:42:04 AM

152480

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 10/18/2016 **Start Qty:** 30.00

30

Customer:

Required Date: 10/24/2016 **Req'd Qty:** 30.00

30

Reference:

Approvals: _____ **Process Plan:** DAS
21 **Date:** OCT 24 2016 **Tooling:** _____ **Date:** _____
9-89 **QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Stop *NS2*

Cust Item ID:

Start Date: 10/18/2016 **Start Qty:** 30.00

30

Customer:

Required Date: 10/24/2016 **Req'd Qty:** 30.00

30

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

120

30

DAS
38

9-59
OCT 31 2016

130

**DAS
30
9-89**

30

NOV 09 2016

Small Fab

1- Bend as per dwg

140

30

OAS
38

Memo

Quality Control

NOV 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 152480

Monday, October 24, 2016 11:42:04 AM

152480

Page 3

Item ID: D3556-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: R44 Bearpaw Clamp
Start Date: 10/18/2016 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 10/24/2016 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>ST512</i>	0.00							NOV 14 2016
150									
Packaging	Memo	0.05				<i>30x</i>	DAS 26 9-89		
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160							DAS 21 9-89		
QC	Memo	0.50							NOV 15 2016
Quality Control									

DAS 21
9-89 NOV 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, October 24, 2016 11:42:03 AM

Work Order ID: 152480

152480

Parent Item: D3556-1

D3556-1

Parent Item Name: R44 Bearpaw Clamp

Start Date: 10/18/2016

Required Date: 10/24/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 07-03-23 JLM
IPP Rev:B 08-07-28 per dwg revb (ecn 08-506) DD verified by:EC IPP Rev C
11.07.14 now in-house EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No			sf	72.5700		1.2			
M304S16GA									**			on 10/10/28	
304/316 Sheet .063													

Location

Loc Qty

Loc Code

MAT010

72.57

m135377

7.12

m135559

1.45

m135689

64

1.7

DQA: _____ Date: _____

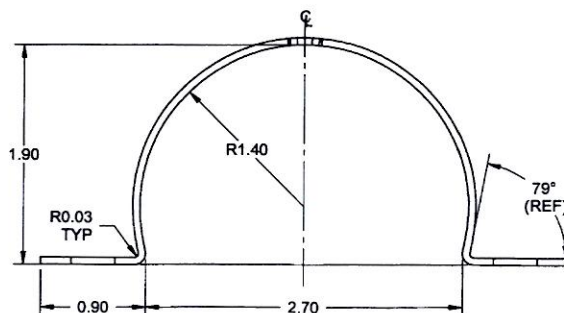
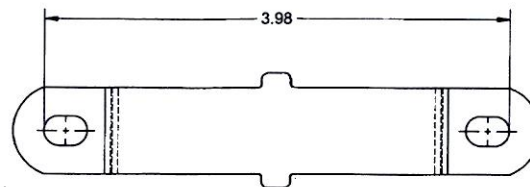


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

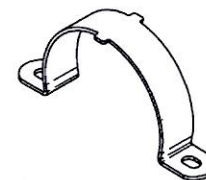
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER : ☐																									



D3556-1 CLAMP

NOTES:

- 1) MATERIAL: MAKE FROM D3556-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.09 lbs
- 8) PART IS SYMMETRIC ABOUT ϕ



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WITHOUT NOTICE
WORK ORDER

NO. 152480 MJS
16-1024

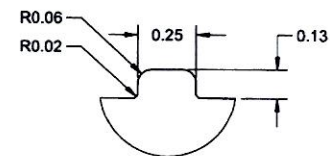
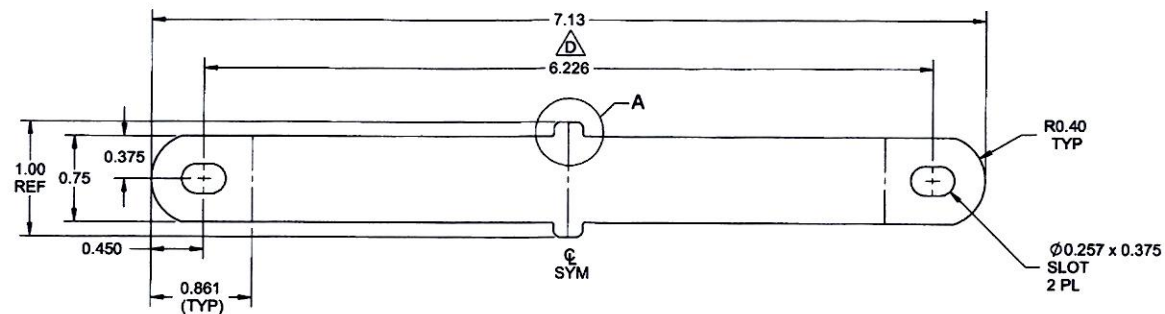
RELEASED

2015 APR 30

ECN 15-549

D	REVISE FLAT PATTERN TO FIT BENT PART; ZN C4-2	VS	15.04.14
C	REVISE NOTES: ZN A8-1, A8-2, REVISE FLAT PATTERN; C7-2, C5-2, B3-2	VS	15.03.23
B	SHEET 1 NOTE 1 MATERIAL WAS MIL-S-5019. SHT 2 ZN B1 SLOT LENGTH WAS 0.357 (REF NCR 257) DRAWING TRANSFERRED TO "B" SIZE & UPDATED TO CURRENT STANDARDS.	AJS	08.07.11
A	NEW ISSUE	CB	07.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	DD	D3556	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
DATE	15.04.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DETAIL A
2 PL

D3556-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE, PER MIL-S-5059 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs
- 8) PART IS SYMMETRIC ABOUT C

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	DD	D3556	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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